

Date: Thursday, 7/19/2007 2:27:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 33676		
Estimate Number	: 12953		
P.O. Number	: N/A	Part Number	: D32595
This Issue	: 7/19/2007 S.O. No. : N/A	Drawing Number	: D3259 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 8/10/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	4 Um: Each
Comment	: Est Rev A New Issue 07-07-19 JLM	Verified By:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s)
 2024-T3 .032 sheet
 Batch: M102942 IB 07-07-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1 IB 07-07-26
 Prog Rev: A1
 2-Deburr if necessary SAD 07/07/26 (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-07-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

(4) x4 counter

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

[Signature] 07-07-31 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:27:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 33676

Part Number: D32595

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/08/01 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/01 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

EP 07/08/01

Job Completion



Jul 07.08.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

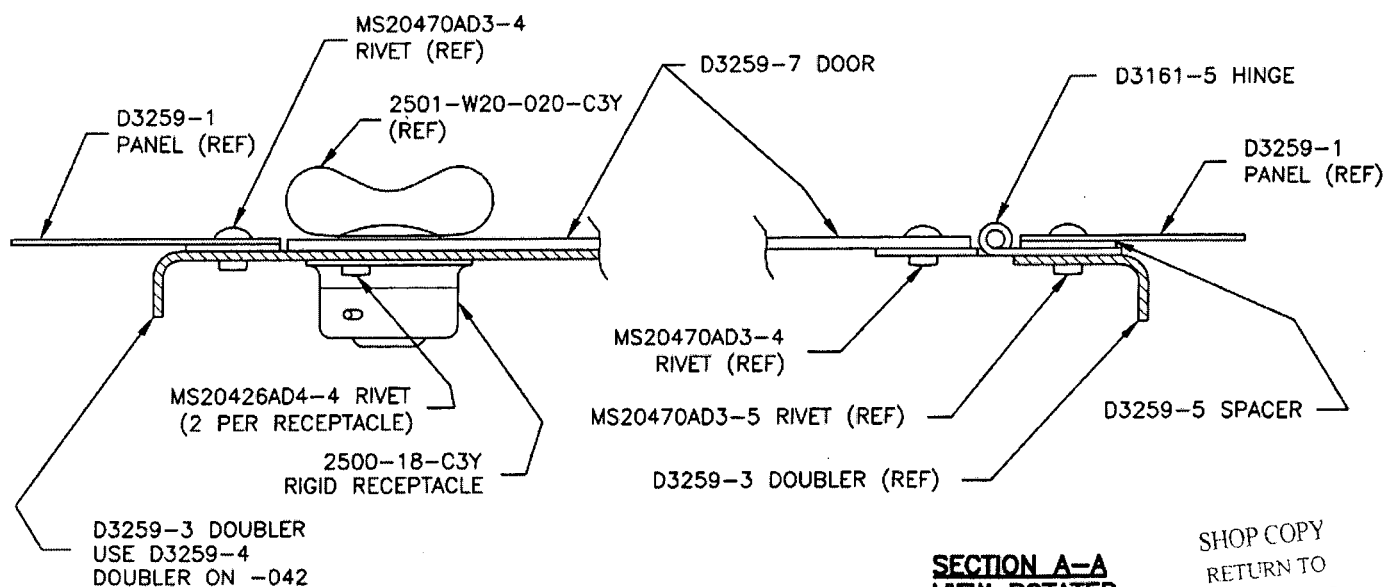
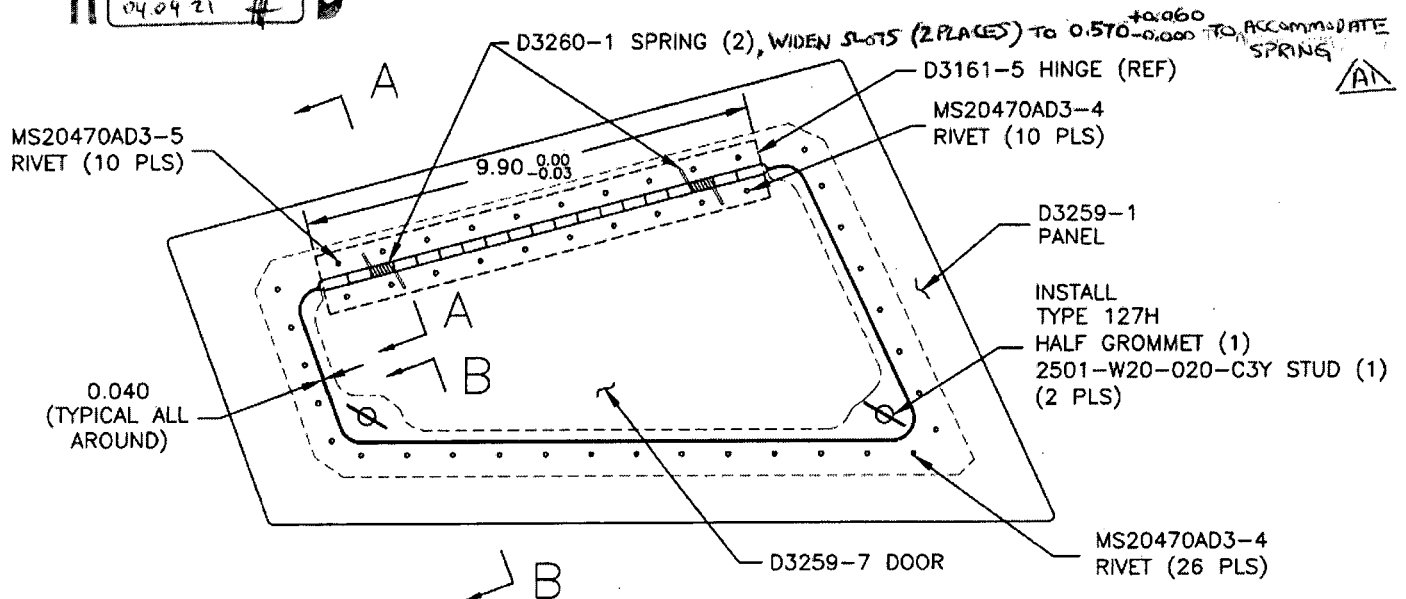
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 6
				D3259	
DATE	04.02.25			TITLE	SCALE
				ACCESS PANEL ASSEMBLY	1:4
A		04.02.25		NEW ISSUE	
A1	UP	04.08.11		WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED
04.04.21



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
33676

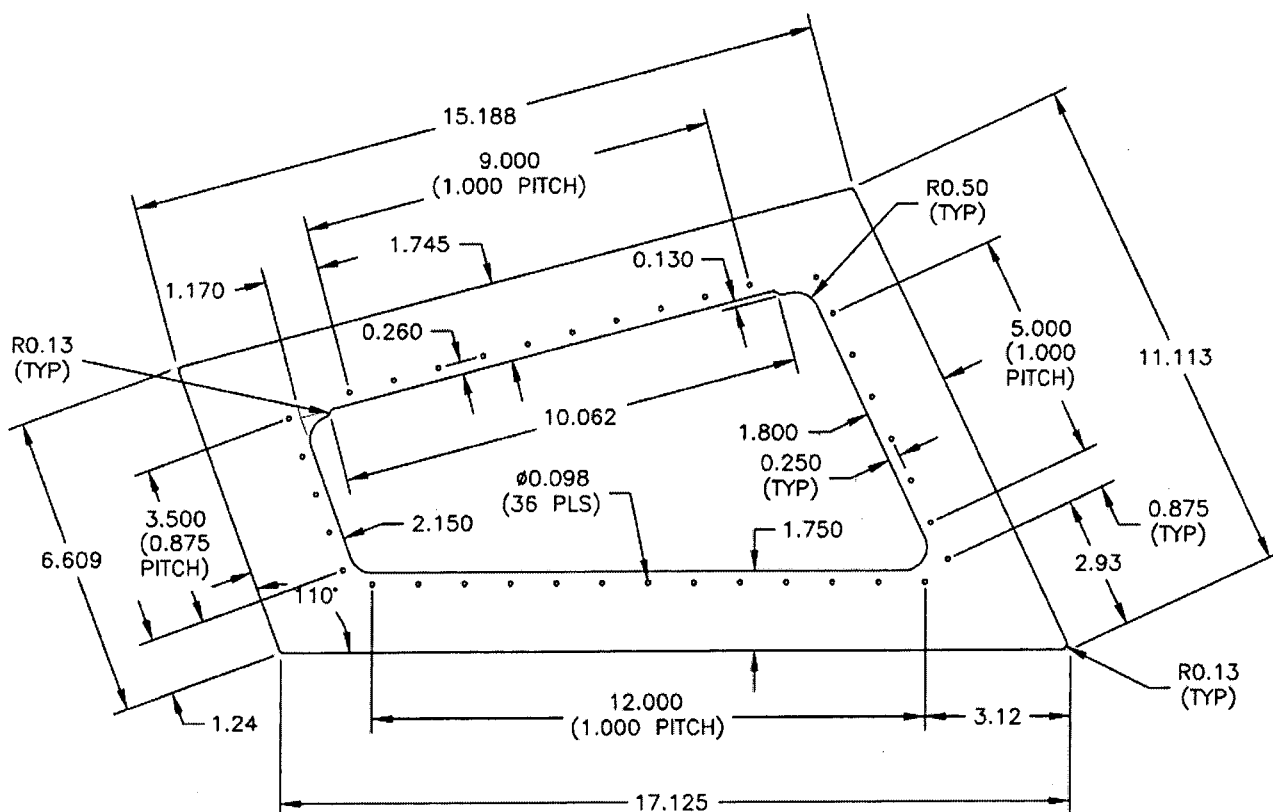
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 33676

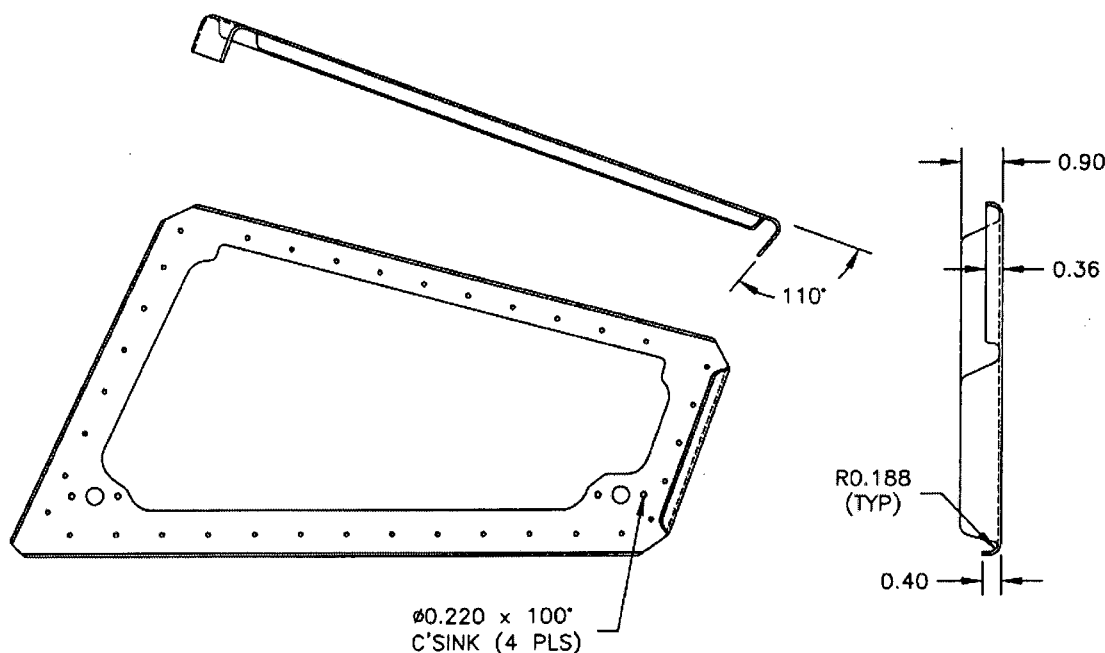
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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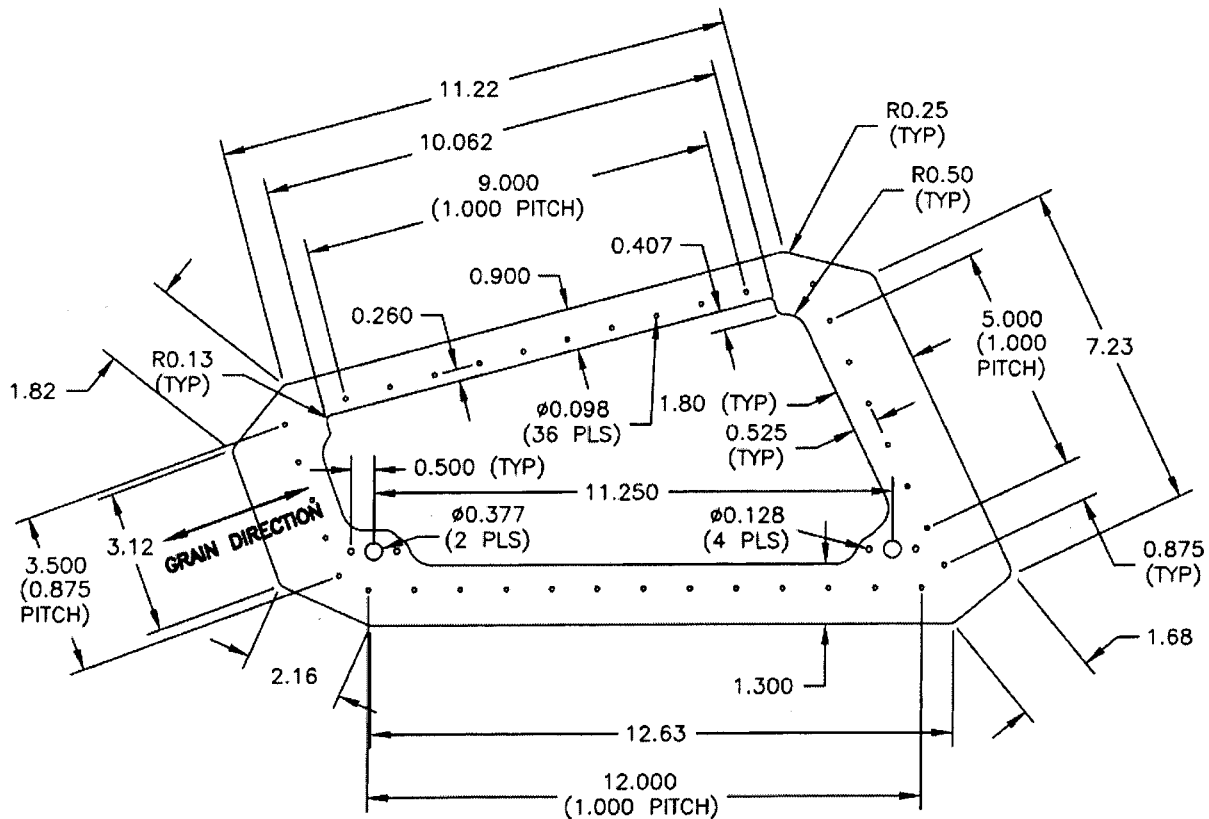
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04.14 *[Signature]*



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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NO 33676

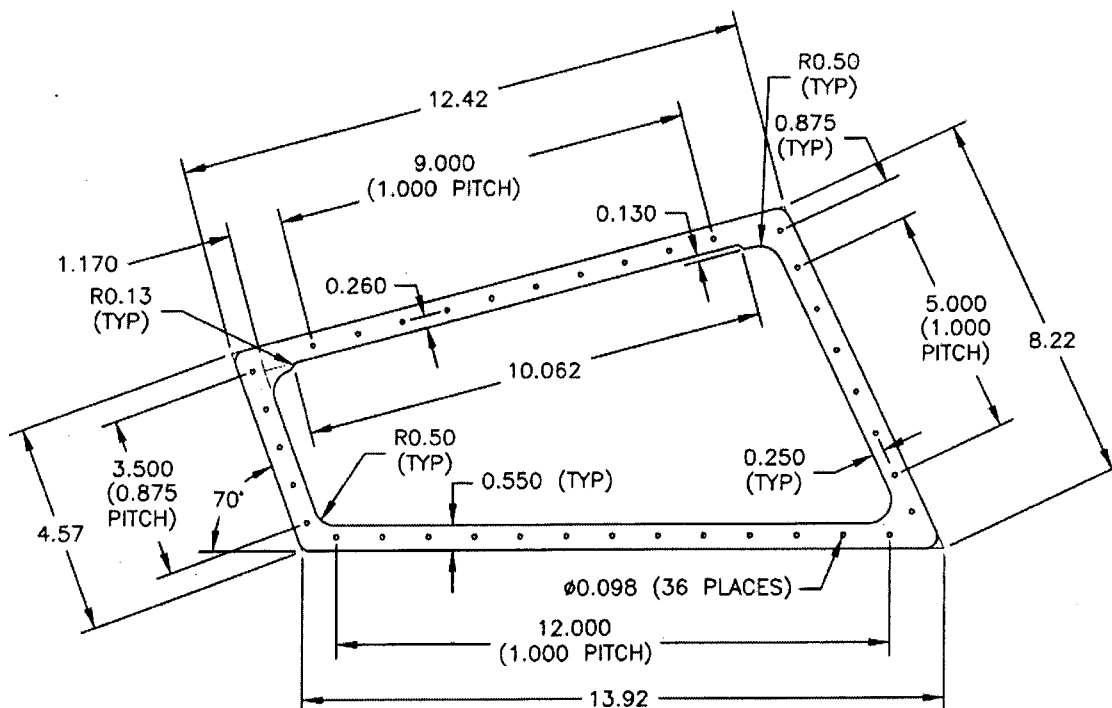
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05 [Signature]



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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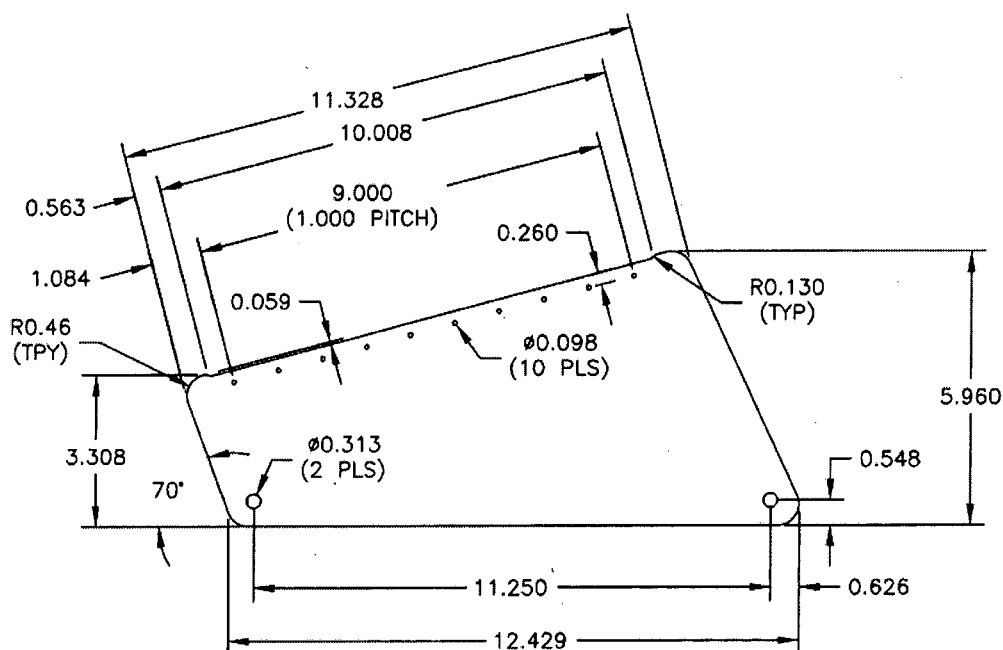
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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